Dart Aerospace Ltd.

Date: Monday, 1/7/2008 11:33:34 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BAFFLE ASSEMBLY
Job Number	: 36596		
Estimate Number	: 11264		
P.O. Number	:	**Part Number**	: D3276041
This Issue	: 1/7/2008 **S.O. No.** :	**Drawing Number**	: D3276 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: B
Previous Run	: 36502	**Material**	:
Written By	:	**Due Date**	: 1/31/2008 **Qty:** ~~10~~ 12 **Um:** Each
Checked & Approved By	: 08.01.07		
Comment	: Est Rev:A New Issue 05-12-06 JLM Est Rev:B Now on Waterjet 06-09-06 JLM		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	M6061T6S040	6061-T6 .040 Sheet

12.8583

Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s)
Material: 6061-T6 (QQ-A-250/11) 0.040" thick
(M6061T6S.040)
Batch: 106747 HB 8-1-10

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3276
Dwg Rev: B HB 8-1-10 (12)
Prog Rev: B

2-Deburr if necessary HB 8-1-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-1-10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK 28/01/10 (12)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Roll as per Dwg D3276 DB 08/01/15 (12)

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D3276041

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Form as per Dwg D3276	SB 08/01/15 (12)
7.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	08/01/15 (x12)
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	BR 08-01-16 (12)
9.0	POWDER COATING	POWDER COATING
	M/106379	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	FL 08/01/17 (12)
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	BR 08-01-17 (12)
11.0	D2464	3/4 Seal
	Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s) Pick: Qty Part Number Description Batch 27.0" D2464 Neoprene Seal B35433	AS 08/01/18 (x12)
12.0	D32763	Decal
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3276-3 Decal 36523x9 B36633	AS 08/01/18 (x12)
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3276	SB 08/01/21 (12)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:33:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BAFFLE ASSEMBLY

Job Number: 36596 **Part Number:** D3276041

Job Number:

Seq. #:	Machine Or Operation:	Description :
14.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	08/01/22 (12)
15.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST179	AS 08/01/22 (X12)
16.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	08.01.23

Job Completion

2008/1/23

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36596
Description: Baffle	Part Number:	D3276-1
Inspection Dwg: D3276 Rev: B		Page 1 of 1

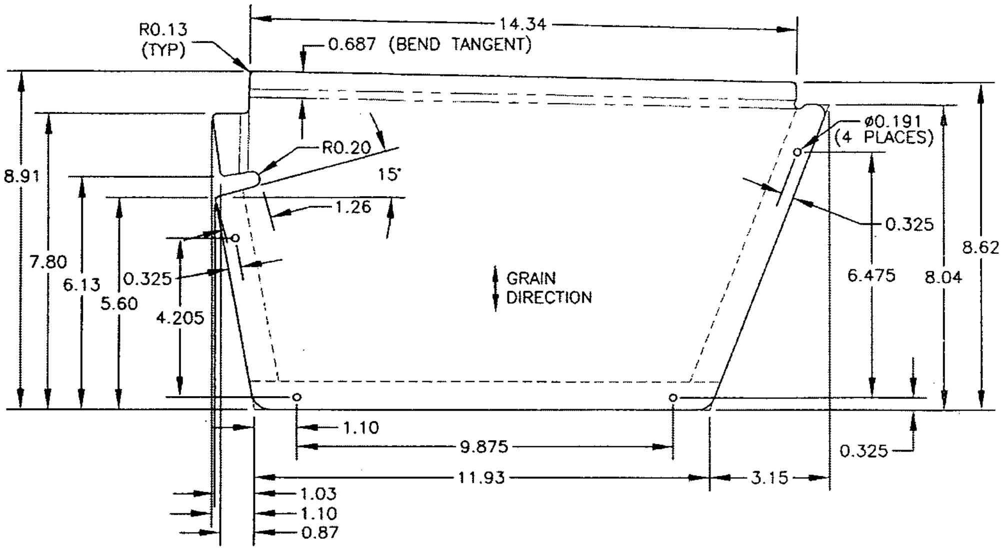
FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

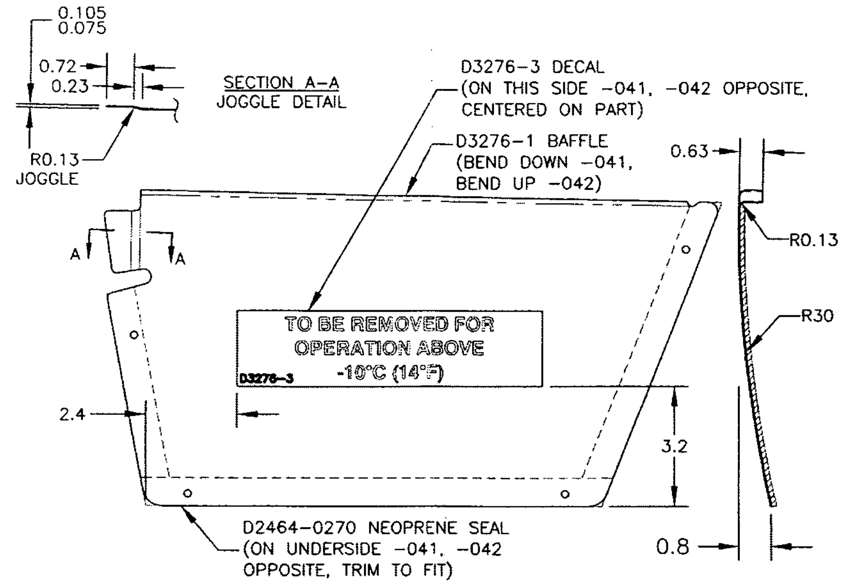
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.34	+/-0.030	14.34	X			
8.62	+/-0.030	8.62	X			
8.04	+/-0.030	8.04	X			
Ø0.191	+0.005/-0.000	.193	X			
0.325	+/-0.005	.325	X			
11.93	+/-0.030	11.93	X			
9.875	+/-0.005	9.875	X			
5.60	+/-0.030	5.62	X			
7.80	+/-0.030	7.80	X			
8.91	+/-0.030	8.91	X			
1.26	+/-0.030	1.26	X			
Grain Direction	N/A	Good	X			

Measured by:	LB	Audited by:	[signature]	Prototype Approval:	N/A
Date:	8-1-9	Date:	08/01/10	Date:	N/A

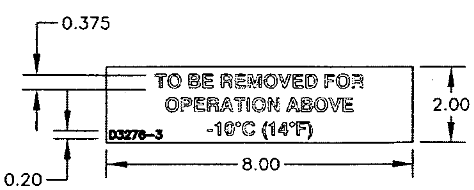
Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D044-717-011	KJ/JLM [signature]	[signature]



D3276-1 BAFFLE (FLAT PATTERN)
1) MACHINE PER DWG FILE "D3276-A.DWG"
2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
4) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



D3276-3 DECAL
1) RED LETTERING ON WHITE ADHESIVE BACK
2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36596

RELEASED 05.02.02

REV	DATE	DESCRIPTION
B	05.01.25	LABEL NOW -10°C; CURVE PART
A	05.01.07	NEW ISSUE

DESIGN: CP | DRAWN BY: CP | CHECKED: [signature] | APPROVED: [signature] | DATE: 05.01.25

DART — DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA

DRAWING NO.: D3276 | REV. B | SHEET 1 OF 1

TITLE: BAFFLE ASSEMBLY | SCALE 1:3